

QTY	QTY	Part Number	Description
-041	-043		
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

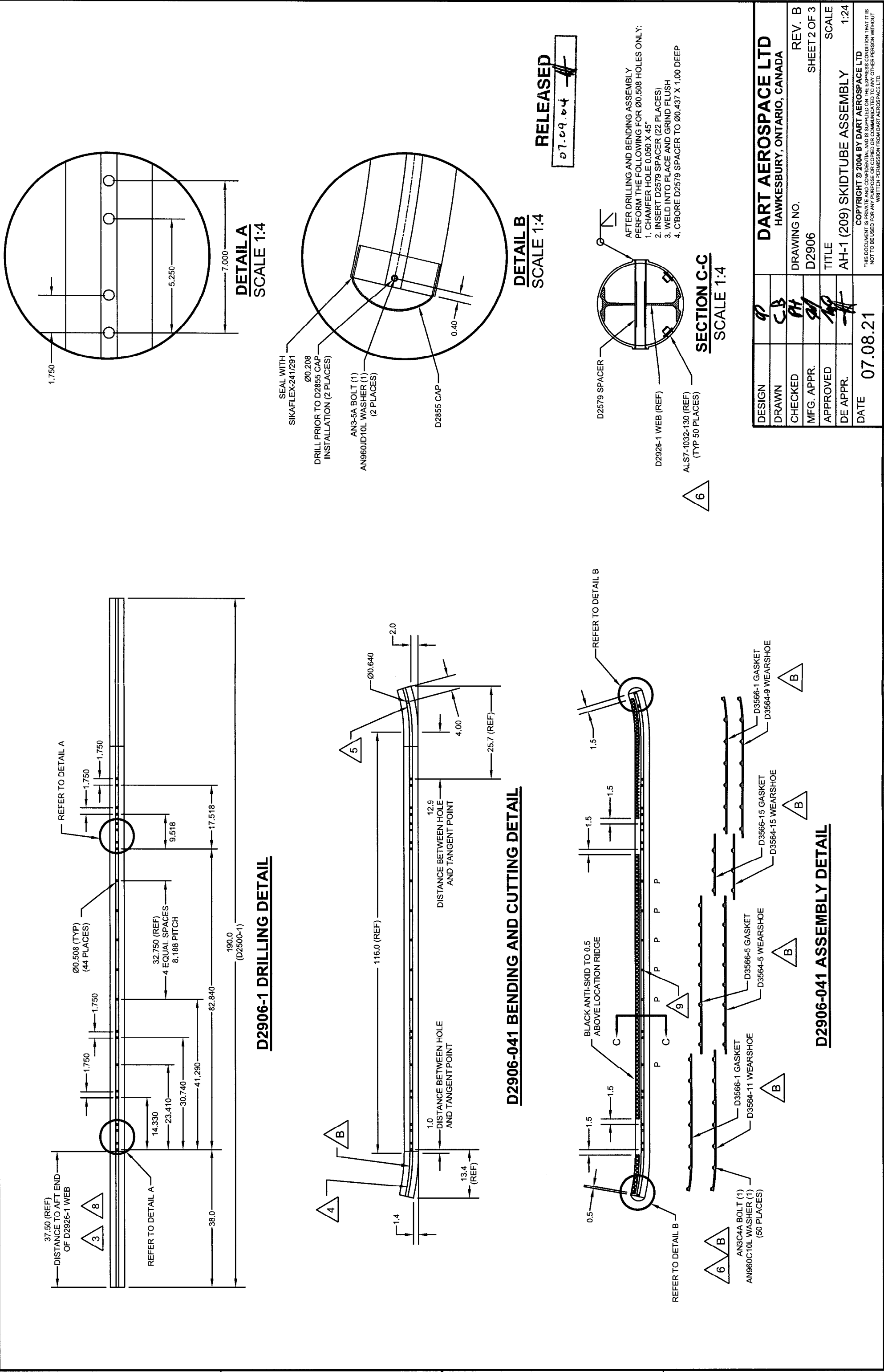
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

RELEASED

07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE LTD	
DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>GP</i>	D2906	SHEET 1 OF 3
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
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D2906-1 DRILLING DETAIL

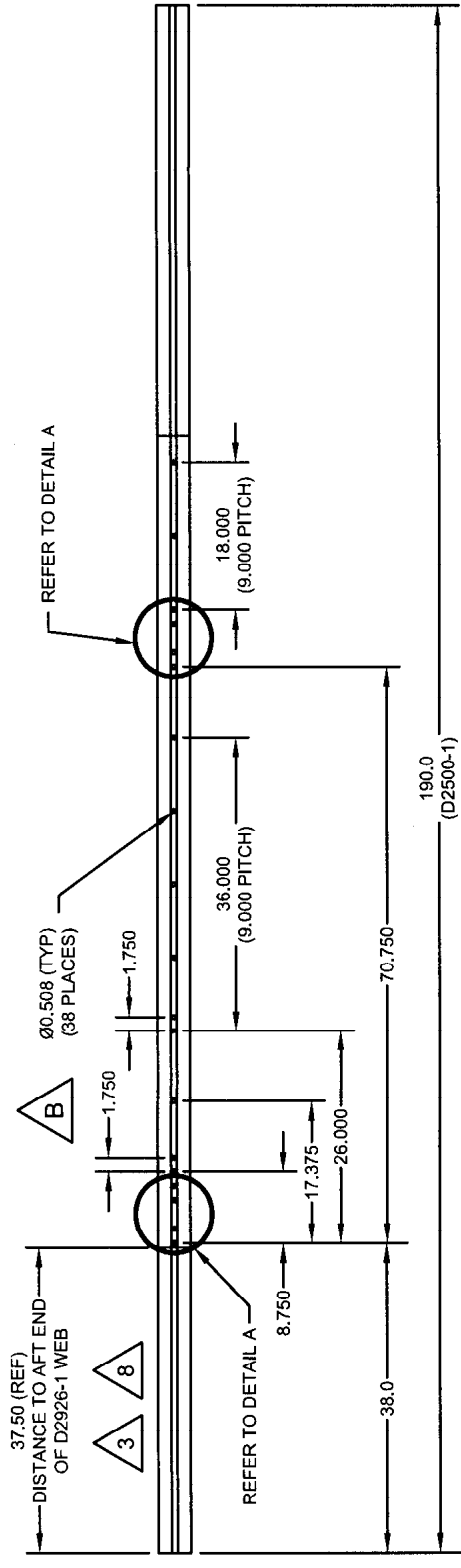
D2906-041 BENDING AND CUTTING DETAIL

D2906-041 ASSEMBLY DETAIL

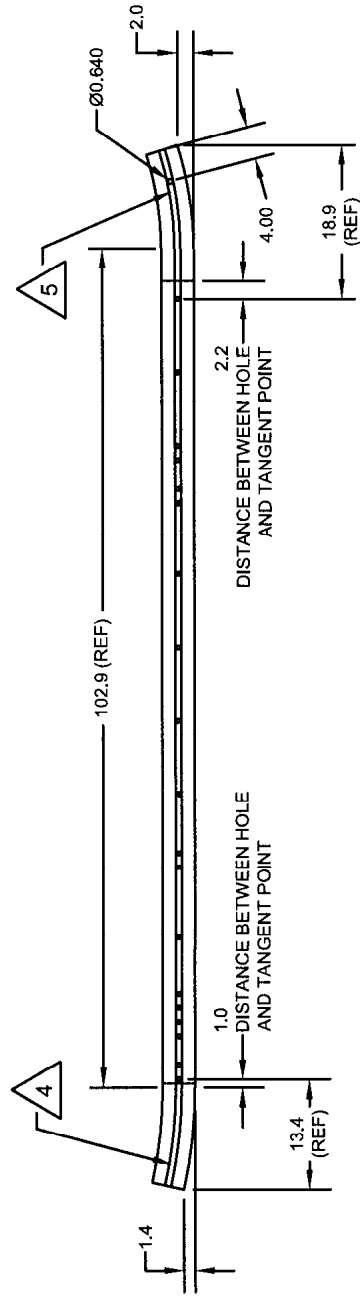
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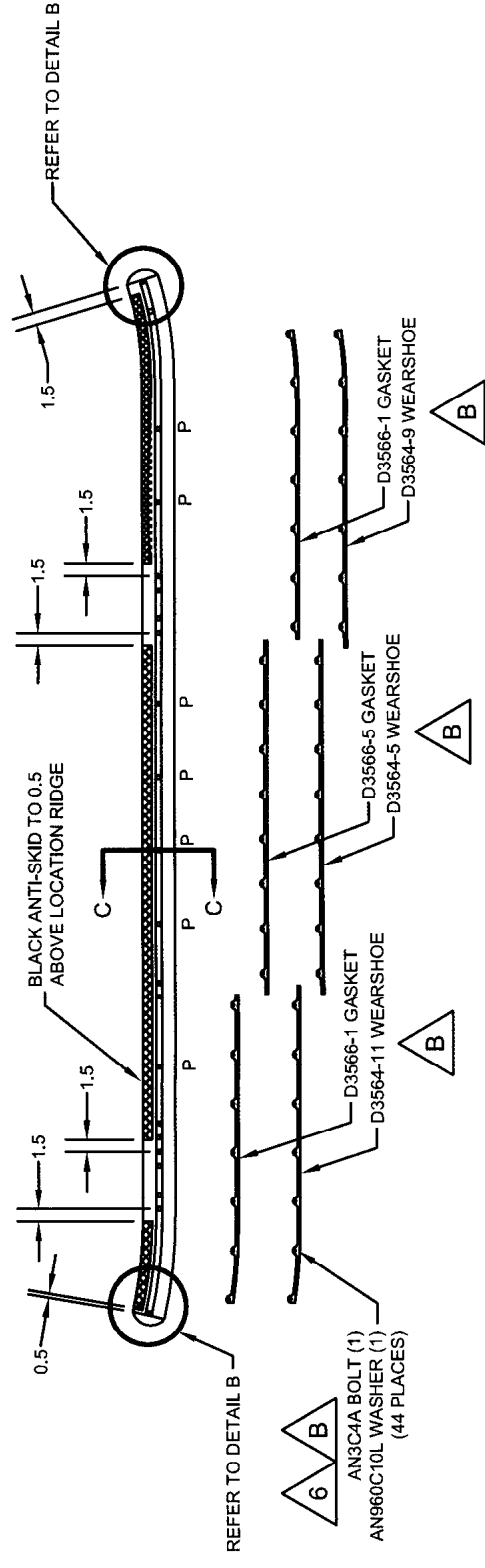
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DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P.H.	DRAWING NO.	REV. B
MFG. APPR.	M.P.	D2906	SHEET 2 OF 3
APPROVED	M.P.	TITLE	SCALE
DE APPR.		AH-1 (209) SKIDTUBE ASSEMBLY	1:24
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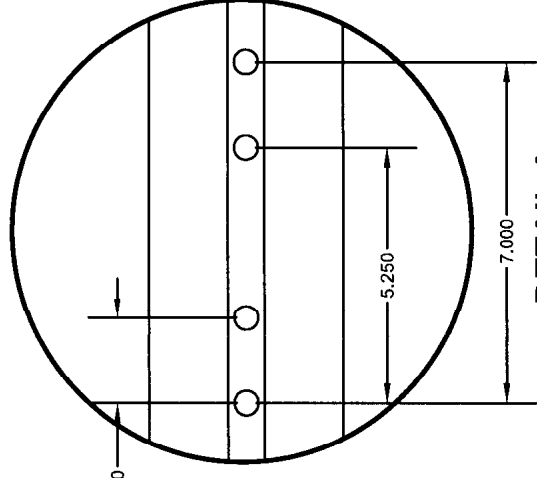
D2906-3 DRILLING DETAIL



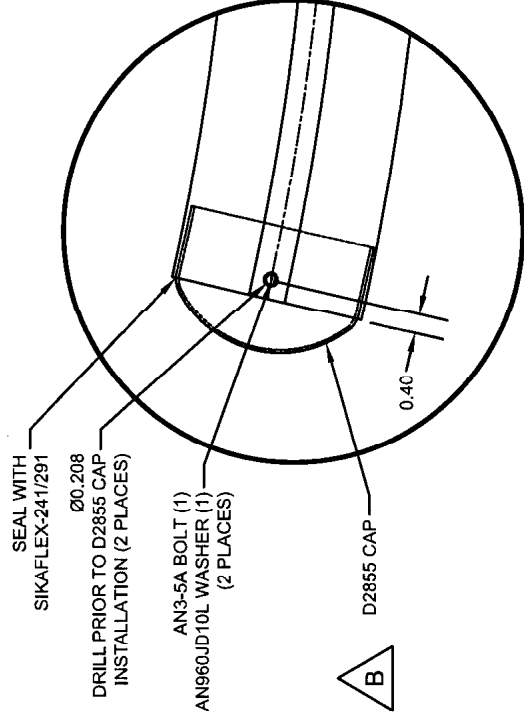
D2906-043 BENDING AND CUTTING DETAIL



D2906-043 ASSEMBLY DETAIL



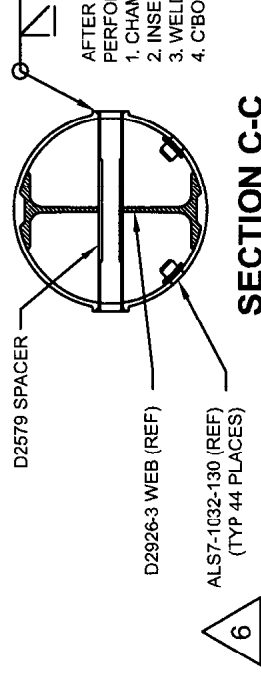
DETAIL A
SCALE 1:4



DETAIL B
SCALE 1:4

RELEASED

07.09.04



SECTION C-C
SCALE 1:4

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø.508 HOLES ONLY:**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B D2906 SHEET 3 OF 3 TITLE SCALE AH-1 (209) SKIDTUBE ASSEMBLY 1:24 COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
DRAWN	CB	
CHECKED	PH	
MFG. APPR.	SM	
APPROVED	MD	
DE APPR.	TH	
DATE	07.08.21	

DRAWING NO. D2906	TITLE AH-1 (209) SKIDTUBE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2906-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN A.P.	CHECKED		MFG. APPR.	APPROVED		DE APPR.	
DATE 12.05.28	DATE 12.05.28		DATE 12.05.31	DATE 12.05.31		DATE 12.05.31	

PURPOSE:
CHANGE ALL C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:
PARTS LIST IS AMENDED AS FOLLOWS:

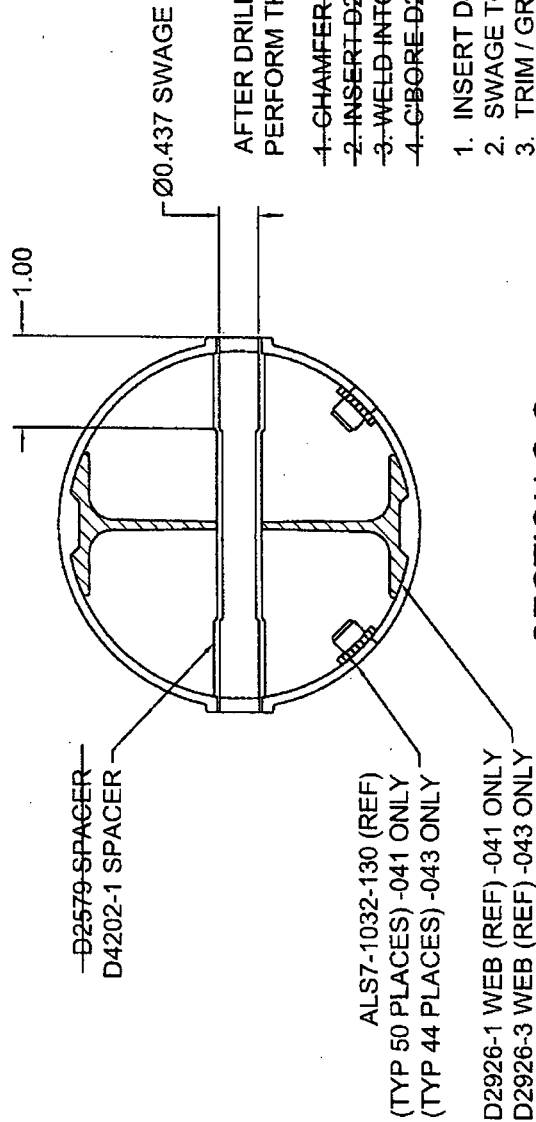
WAS

QTY	QTY	PART NUMBERS	DESCRIPTION
-041	-043		
22	19	D2579	CROSS BOLT SPACER

IS

22	19	D4202-1	SPACER
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SECTION C-C ON SHEETS 2 & 3 ARE AMENDED AS FOLLOWS FOR ALL HOLES THAT WERE ORIGINALLY C'BORED:



SECTION C-C A2-2
NOT TO SCALE A2-3

RELEASED
2012-06-05